

Date: Thursday, 5/11/2006 11:52:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT STRUT ASSEMBLY
Job Number	: 27063		
Estimate Number	: 11242		
P.O. Number	: N/A	Part Number	: D3437043
This Issue	: 5/11/2006 S.O. No. : N/A	Drawing Number	: D3437 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/17/2006
Checked & Approved By	: <u>06.05.11</u>	Qty:	4 Um: Each
Comment	: Est. A 05.05/06 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34371	Foot
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Foot

Pick:

Qty	Part Number	Description	Batch
1	D3437-1	Foot	B 27064 /

2.0	D34373	Clip
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clip

Pick:

Qty	Part Number	Description	Batch
1	D3437-3	Clip	B 23408C /

3.0	D34379	Eye Bolt
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Eye Bolt

Pick:

Qty	Part Number	Description	Batch
1	D3437-9	Eye Bolt	B 27066 /

4.0	AN960C516	WASHER
-----	-----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	AN960C-516	Washer	M 17697 /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/11/2006 11:52:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT STRUT ASSEMBLY

Job Number: 27063

Part Number: D3437043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS21083N5

Self Locking Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Self Locking Nut

Pick:

MS21043-5

Qty Part Number Description

1 MS21083N5 Self Locking Nut

Batch

M18535

~~M17694~~

SB 06/05/18

(4)

(P.T.O)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3437 Dwg Rev: A

SB 06/05/18

(4)

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

P.T.O

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST434

P 6/15/23

(4)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/05/25

(4)

Job Completion



06-05-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-05-23	6.1	Add QC 5 after ASS'Y permanent change <i>J</i> parts inspected QCS by <i>J</i> 06-05-23 (4)					<i>J</i> 06-05-23	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *DB* Date: *06/05/25*

NOTE: Date & initial all entries

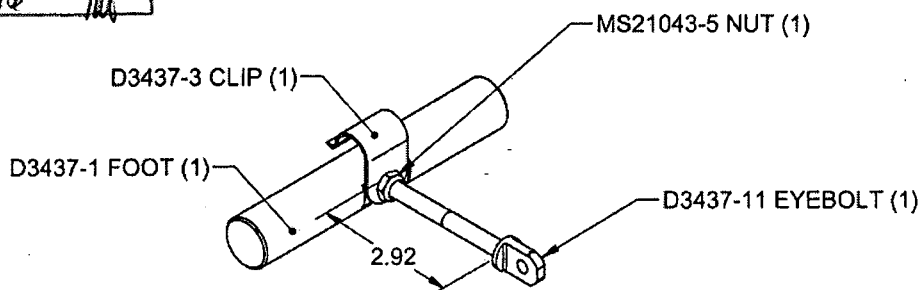
QA: N/C Closed: _____ Date: _____



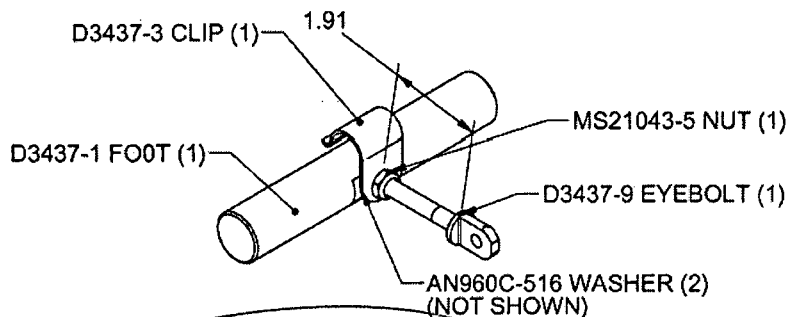
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

RELEASED

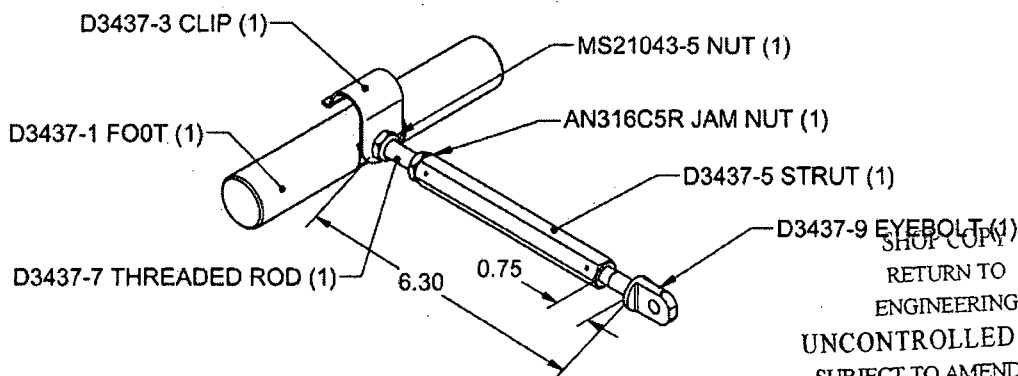
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D3437-041 AFT STRUT ASSEMBLY



D3437-043 AFT STRUT ASSEMBLY



D3437-045 AFT STRUT ASSEMBLY

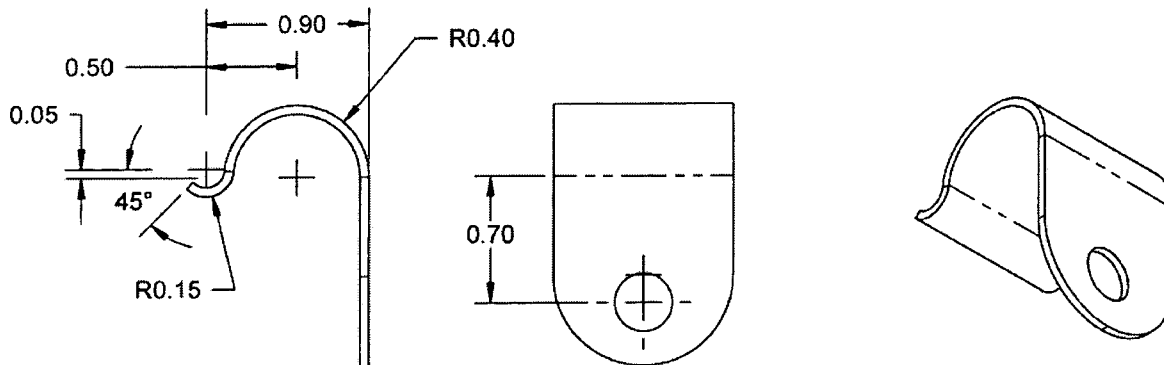
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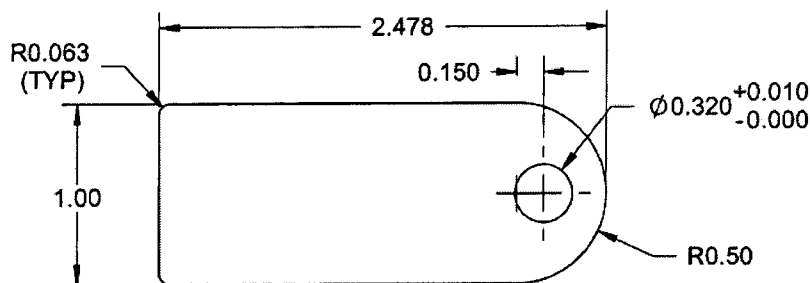
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DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

RELEASED05.08.16 *[Signature]*

D3437-3 CLIP
SCALE 1:1



D3437-3
FLAT PATTERN

D3437-3 CLIP:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

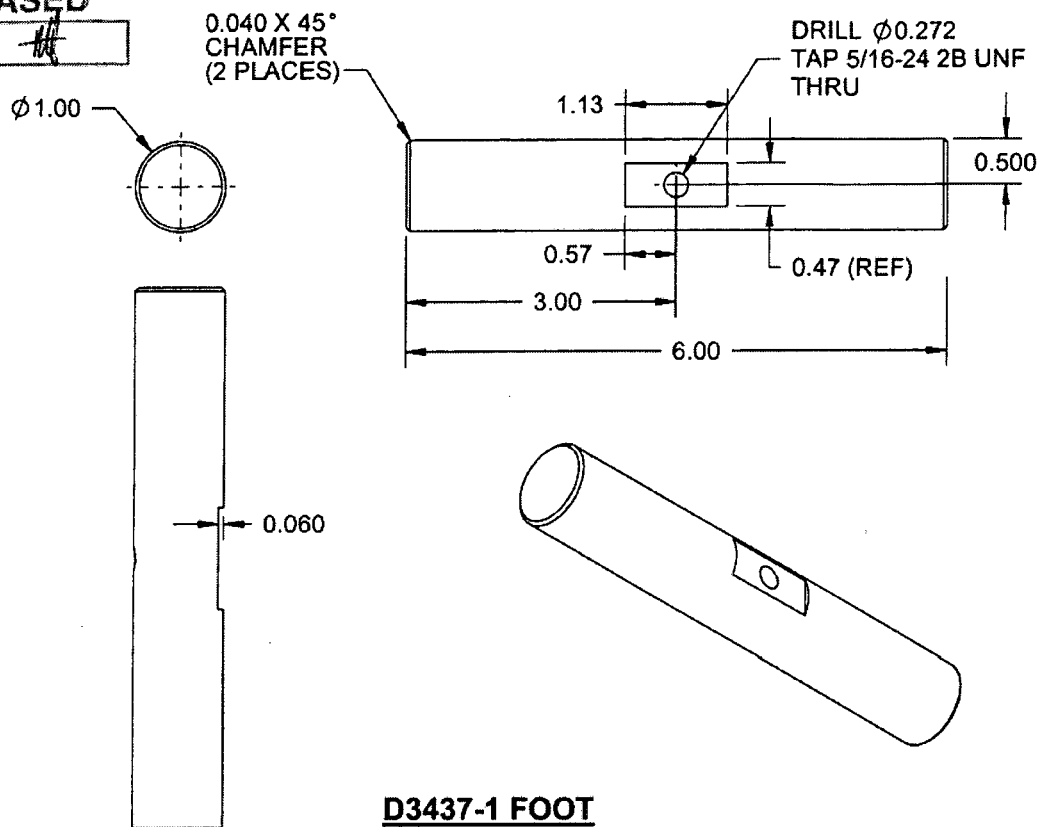
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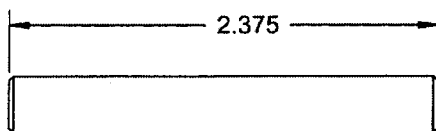
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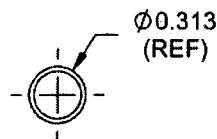
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2

RELEASED05-08-16 *[Signature]***D3437-1 FOOT****D3437-1 FOOT:**

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR (REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**D3437-7 THREADED ROD****D3437-7 THREADED ROD:**

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



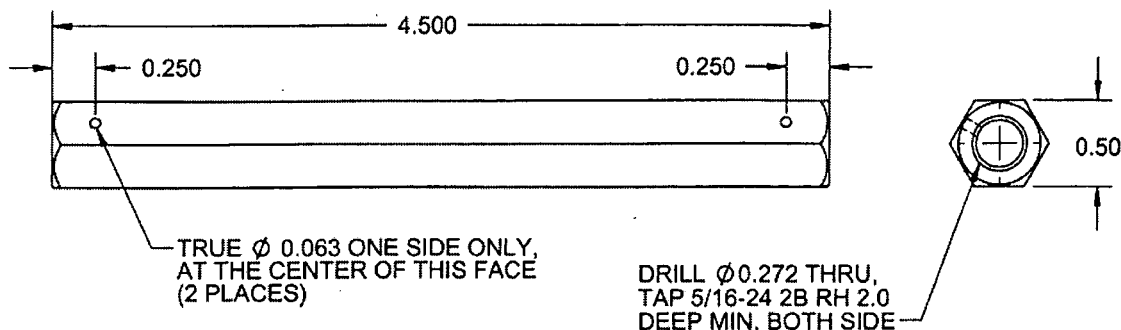
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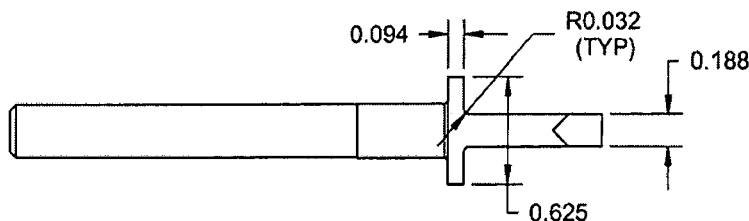
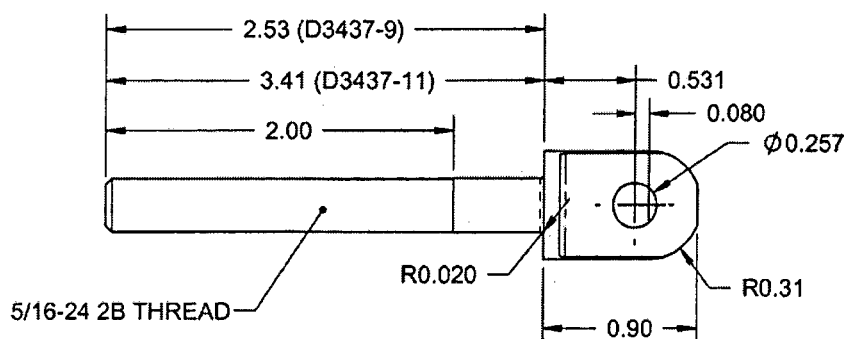
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DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

**D3437-5 STRUT:**

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**05-08-16 *[Signature]***D3437-9/-11 EYEBOLT:**

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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